

Work Order ID 151614-2

Tuesday, October 04, 2016 11:05:50 AM

151614

Page 1

Item ID: D2855-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 10/7/2016 Start Qty: 50.00 *50*
 Required Date: 10/19/2016 Req'd Qty: 50.00 *50*
 Reference: DAS
 Cust Item ID:
 Customer:

Approvals: Process Plan: 21 Date: OCT 04 2016 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	Rev B								
100	PURCHASING	0.00							DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 3388 S								
	Cast per Dwg D2855								
	Material Release Note Required								
	Supplier: Metallurgie SYCA								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.17							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							DAS 9 9-89
120									
QC	Memo	0.00							
Quality Control									

50 OCT 06 2016

50x 50/6-12-1

(55) 16.12.06

Work Order ID 151614

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Item ID: D2855-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap

Start Date: 10/7/2016 Start Qty: 50.00

50

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130					DAS				
Small Fab	Memo	0.33			30	42			DEC 12 2016
Small Fab	1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64"				9-89				
142		0.00							
142						42	0		DAS
Mill Conv	Memo	0.00							32
Conventional Milling Machine	1- MILL to length as per dwg use DT10248 JAWS 2- Deburr								9-89
									17-01-20
143	QC5- Inspect part completeness to step on W/O	0.00							
143						42			DAS
QC	Memo	0.17							38
Quality Control									9-89

JAN 20 2017

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**DAS
15
9-89**

Work Order ID 151614

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151614

Page 4

Item ID: D2855-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cap

Stop

NS2

Start Date: 10/7/2016 Start Qty: 50.00

50

Cust Item ID:

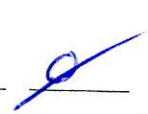
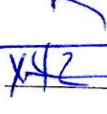
Required Date: 10/19/2016 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	 QC5- Inspect part completeness to step on W/O Memo	0.00 0.17				<u>x42</u>	<u>q</u>	<u>all 12/02/03</u>	 DAS 15 9-89
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP001</u> Memo LOCATION : FP001	0.00 0.08				<u>(x42)</u>	<u>q</u>	<u>2012/02/03</u>	 BEB.
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.83				<u>x42</u>	<u>q</u>	<u>all 12/02/03</u>	 DAS 15 9-89

DAS 21 9-89

FEB 03 2017

FEB 03 2017

Picklist Print

Tuesday, October 04, 2016 11:05:53 AM

Page 1

Work Order ID: 151614

151614

Parent Item: D2855-3

D2855-3

Parent Item Name: Cap

Start Date: 10/7/2016

Required Date: 10/19/2016

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2855P		Purchased	No			110	Each	0.0000	1	50			
D2855P									**				
Cap													
ALS7-1032-225	AELS8-1032-225	Purchased	No			170	Each	209.0000	2	100			
A S7-1032-225									**				
Insert													

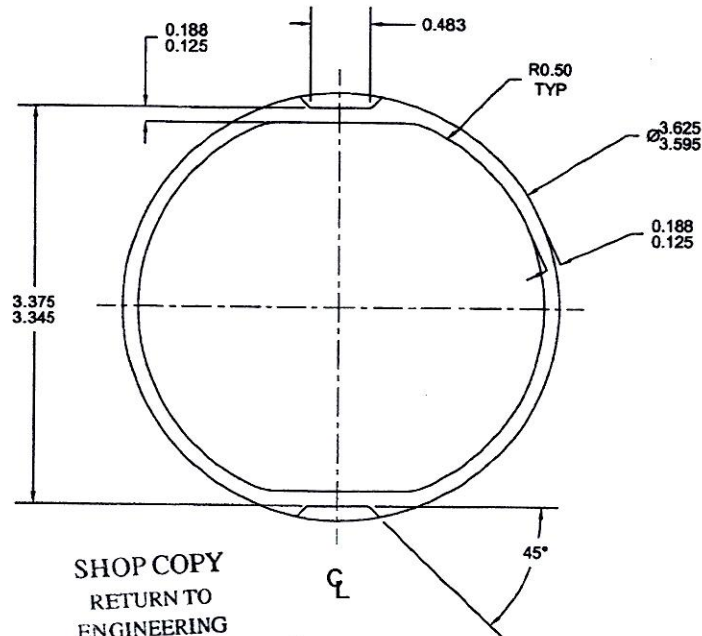
50x 50/6-12-1
*84 BEB 2017/02/03

***ALS4-1032-225**

Location	Loc Qty	Loc Code
FG	120	
118520	120	
FP001	89	
m131657	16	
m133799	73	

***M135998**

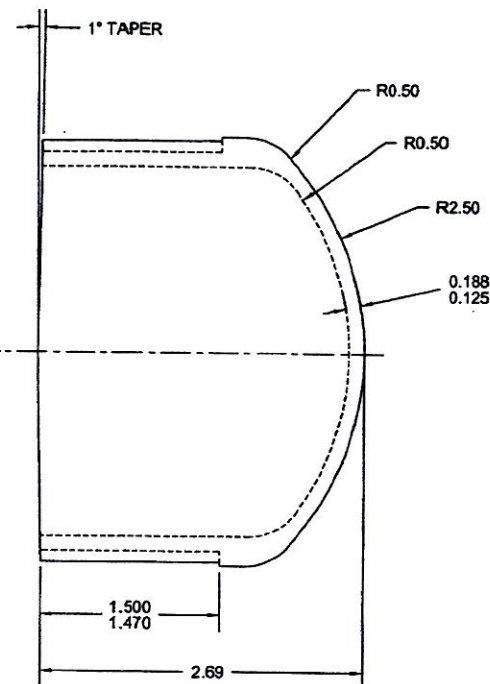
x84



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 1511614 ML5
1670-04

D2855C CASTING DETAIL

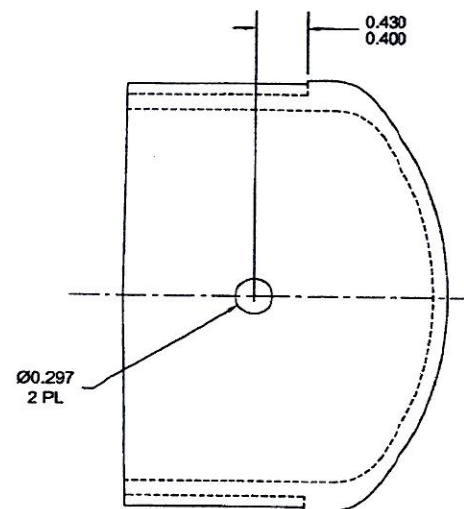
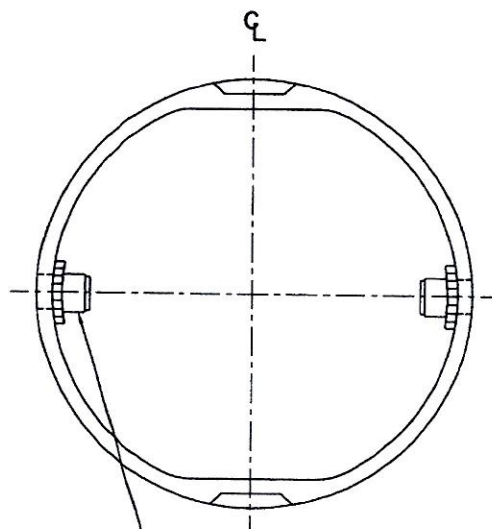


NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

RELEASED
09/07/15

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2855	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

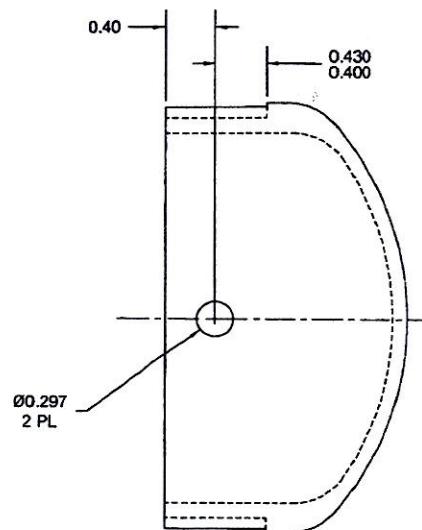
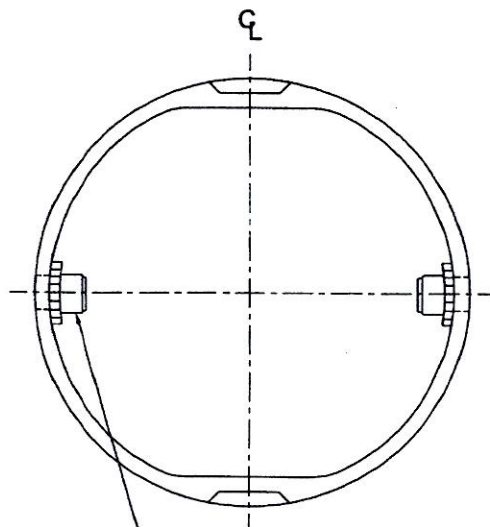
D2855 CAP
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

RELEASED
2/17/15 MP

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
2017/11/13

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO33885

Purchase Order Date 10/6/2016 8:56:43 AM

PO Print Date 10/6/2016

Page Number 1 of 2

Order From :

VC-MSY01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

METALLURGIE SYCA
500 PRINCIPALE

ST.DOMINIQUE, QUEBEC JOH 1LO

E-MAILED

OCT 06 2016

Contact Name

Vendor Phone 450-261-0853

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

REVISED \$

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P	Cap	10/31/2016 Yes 10/31/2016		100.00 Each	\$14.25	\$1,425.00
AS PER DWG D2855 REV. B 50 X B151613 TO MAKE D2855 50 X B151614 TO MAKE D2855-3 DAS 9 9-89 50x Spd/6-12-1							Line Total: \$1,425.00
4	71401-45	ADMIN FEES CERTIFICATE OF COMPLIANCE	10/31/2016 Yes 10/31/2016		1.00	\$75.00	\$75.00
Line Total:							\$75.00

PO Instructions: Fedex Acc#151793240

Note:

10/6/2016

METALLURGIE SYLAIN
500 RUE PRINCIPALE
ST-DOMINIQUE, QUÉBEC
J0H 1L0

N° D'ENR. DE TAXE
TAX REG. NO.

N° DE COMMANDE
ORDER NO.

Play the Test from 2008/01/01 to 2008/01/01

DATE 30-11-2016

VENDU À

SOLD TO

SPACE LTD

ADRESSE

ADDRESS

1270, ABERDEEN STREET

EXPÉDIÉ À

SHIP TO

HAWKESBURY, ONT

ADRESSE

ADDRESS

KGA-1K7

DATE D'EXPÉDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDEUR
SALESPERSON

115

D-2855

1 Box x 60 Pcs x 32 Pcs

1 Box x 55 Pcs x 30 Pcs

Take 50x
8/10/12-1.

TRANSPORT FEDEX

THANKS FOR YOUR SUPPORT

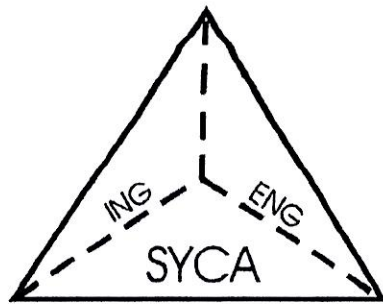
TOTAL

370980

SIGNATURE

Blueline DCB27

FORMULAIRE DE VENTE - SALES ORDER ©Blueline® 2010



MÉTALLURGIE SYCA Inc.

500, Principale

St-Dominique, Québec

JOH 1LO

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

W W W . S Y C A - I N C . C O M

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2016-NOV-29TH

SHIPPING MEMO: 370980

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	115	D-2855	33885

All item specify in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ15112016

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

-VISUAL INSPECTION: DONE

-DIMENSIONNAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

RESPONSIBLE: CARL JOBIN ING.

SA-101

rialco Inc.
900 E. 14th Street
Chicago Heights, Illinois
60411-3002

Certificate of Analysis

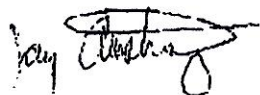
Alloy	.356.1	Heat #	JSF211
-------	--------	--------	--------

Bundle #	Weight
JSF211-046	1,957
JSF211-047	1,954
JSF211-048	1,943
JSF211-049	1,558

Chemical Composition

Chemical Composition											
Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Pb	Sn	Sr
7.200	0.130	0.00	0.02	0.41	0.00	0.00	0.00	0.17	0.000	0.000	
Ca	Na	Be	Bi	B	P	Cd	Co	Sb	V	Zr	

We certify that the above analysis is the result obtained in our laboratory for the heat indicated.
This shipment is free of radiation.



Jay Armstrong
President
Trialco Inc.
09/12/16